Tuesday, 11/14/2006 10:08:31 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number

: 29411

Estimate Number

: 12576

P.O. Number

This Issue

: NIA

: 11/14/2006

Prsht Rev. : NC

First Issue Previous Run : NIA

: 29411

Written By Checked & Approved By

Comment

: Est Rev:A

S.O. No. : WIA

New Issue 06-11-09 JLM

: LARGE FAB ASSY

Drawing Name

: STEP WELDMENT

Part Number

: D3562041

Drawing Number

: D3562 REV A : N/A

Project Number **Drawing Revision**

: A :NIA:

Due Date

Material

: 11/24/2006

Qty:

5 Um:

Each

Additional Product

OIC. Proceed for HAS only

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

Extrusion

D2622120C



Comment: Qty.:

Qty Part #

1.0000 Each(s)/Unit Total: Description

D2622-120C Extrusion 5.0000 Each(s)

Check Material for any Dents or Defects

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 83 15 long as per Dwg D3562

2-Deburr and bevel ends for welding

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

D2734

206 Step Endplate



Comment: Qty.:

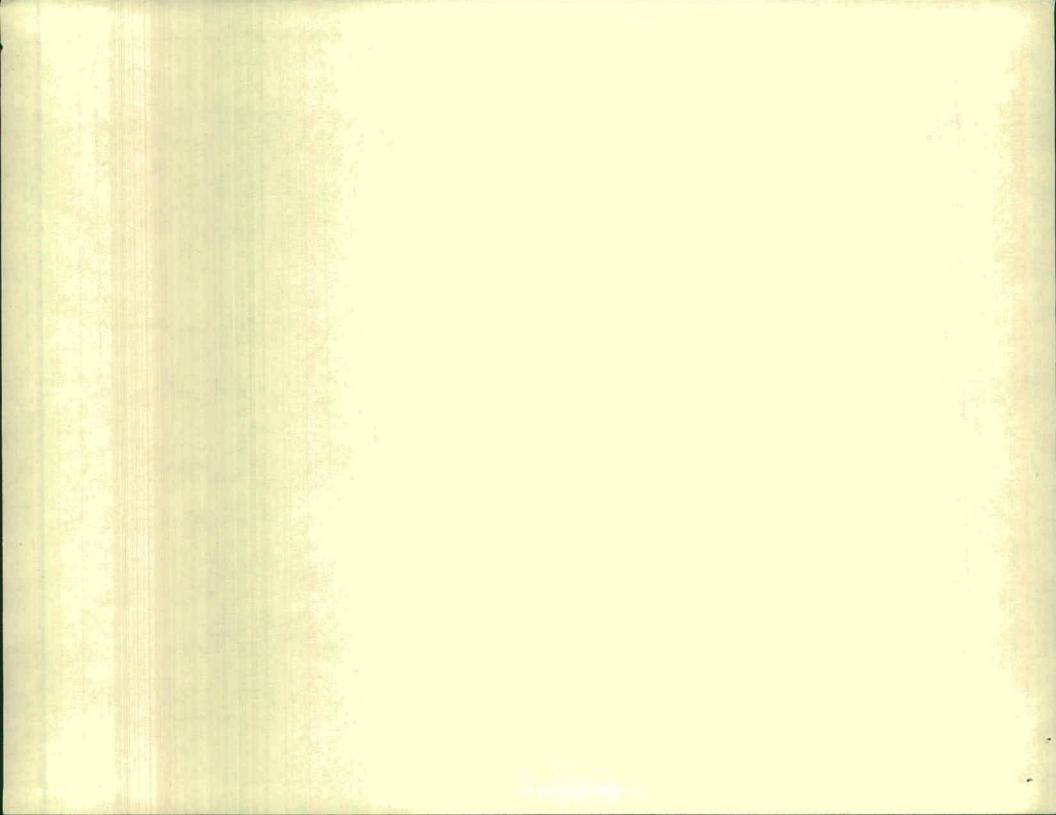
2.0000 Each(s)/Unit Total: 10.0000 Each(s)



Qty Part Number 2 D2734

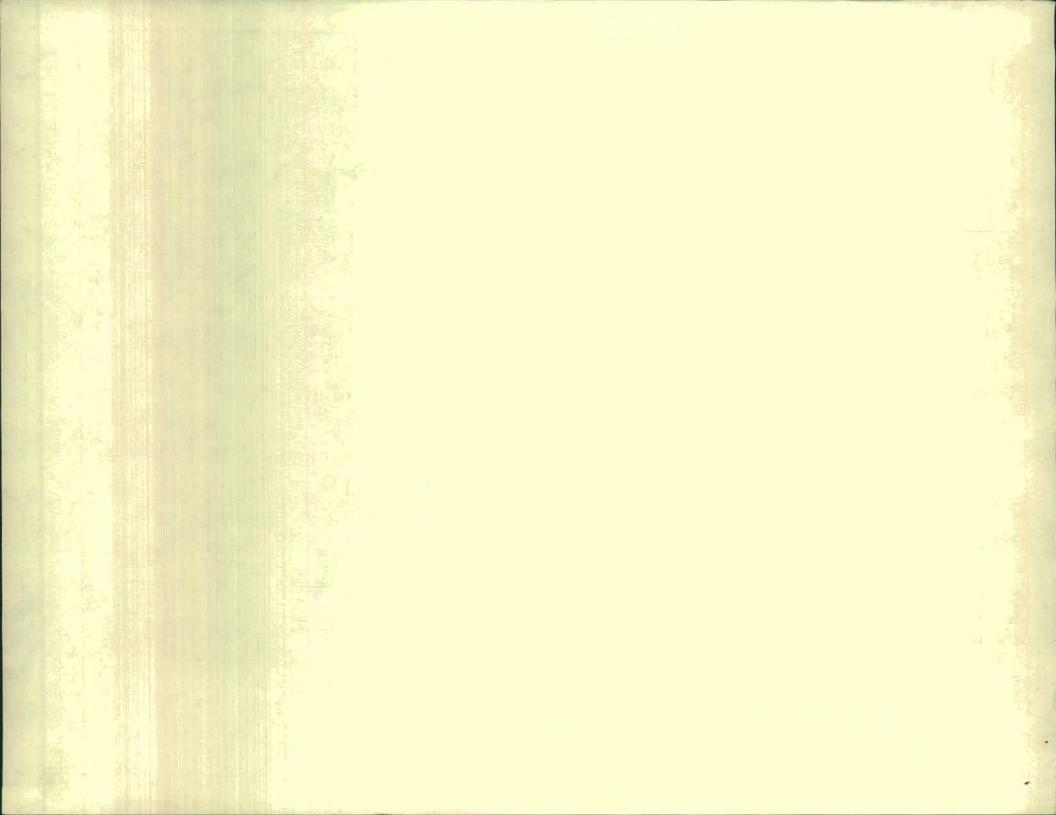


Description Batch End Cap 329340



Tuesday, 11/14/2006 10:08:31 AM **Process Sheet** Kim Johnston Drawing Name: STEP WELDMENT Customer: CU-DAR001 Dart Helicopters Services Part Number: D3562041 Job Number: 29411 Job Number: Description: Machine Or Operation: Seq. #: ARM D35601 5.0 5.0000 Each(s) Total: 1.0000 Each(s)/Unit Comment: Qty.: Pick: 26.12.27 Description Batch **Qty Part Number** 1 D3560-1 D35603 6:0 5.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: ARM Batch: 8-29449 LARGE FABRICATION RESOURCE 1 LARGE FAB 7.0 Comment: LARGE FABRICATION RESOURCE 1 1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. Use DT8893 To Weld Arms Aluminum Rod m100237 \$ m19612 A/R 2-Grind end cap welds flush as per Dwg D3562 VISUAL WELDING INSPECTION QC9 8.0 Comment: VISUAL WELDING INSPECTION INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING1 10.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 LARGE FAB 11.0 Comment: LARGE FABRICATION RESOURCE 1 1-Deburr and bevel aft end for welding. 2-Weld as per Dwg D3562 Batch: M160237 M19612 AL ROD

Dana 2



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 29411

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0

QC5

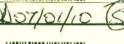
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

HAND FINISHING RESOURCE #1







Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

POWDER COATING

POWDER COATING MUL 391



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

orlully x5

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

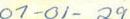
Batch: 10 2098



INSPECT POWDER & OAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



18.0

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Job Completion



L 07101.30

